



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-141
Job Sheet 195706



Part No: D205-634-141

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.00	Skidtubes - 1	
							Skidtubes - 2	
							Skidtubes - 3	MLG
							Skidtubes - 4	
							Skidtubes - 5	
							Skidtubes - 6	
							Skidtubes - 7	
120	Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19		0.00	1.00	Skidtubes - Bend - B4B	MLG
130	Skidtubes - 2 - B4B	1 pcs	7/5/19		0.00	2.00	Skidtubes - 1 - B4B	
							Skidtubes - 2 - B4B	
							Skidtubes - 3 - B4B	MLG
							Skidtubes - 4 - B4B	
							Skidtubes - 5 - B4B	
							Skidtubes - 6 - B4B	
							Skidtubes - 7 - B4B	
140	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	BE
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	



Container No: S187779



Part: D205-634-141

Job No: 195706

Serial No/Batch: S187779

Revision: H/I

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2, FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

150 Skid tubes - 3 - B4B	1 pcs	7/5/19	0.00 2.00	QC 5 - 30	
				QC 5 - 40	
				Skid tubes - 1 - B4B	
				Skid tubes - 2 - B4B	
				Skid tubes - 3 - B4B	MLL
				Skid tubes - 4 - B4B	BE
				Skid tubes - 5 - B4B	
				Skid tubes - 6 - B4B	
160 QC 10	1 pcs	7/5/19	0.00 0.00	Skid tubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	CPC
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	CPC
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.50	QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	JUN 20 2019
				Handfinish - 2 - 3 - B4B	
190 Powdercoat - 1 White GI(A)-B4B	1 pcs	7/5/19	0.00 0.80	Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	DEF 19-08-24
				Powdercoat - 3 - B4B	
200 QC 3	1 pcs	7/5/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	W 14-6-20
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

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				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
210 Handfinish - 3-1- WingWalk-B4B 1 pcs	7/5/19	0.00 1.33	Handfinish - 3 - 1 - B4B		111 14-7-72
			Handfinish - 3 - 2 - B4B		
			Handfinish - 3 - 3 - B4B		
			Handfinish - 3 - 4 - B4B		
			Handfinish - 3 - 5 - B4B		
220 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
230 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
235 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	AUG 26 2019
240 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL
 Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM FT OF D2580-1 REF. ONLY)
 120 - (CNC Delta 100 Bender)1-Bend as per program D2580.C on CNC Bender and Folio FT 16
 130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step.remove
 alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832"REF) as
 per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63
 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod m139011 2-Touch up alodine
 on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per
 QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR
 160 - QC10- Inspect visual per QSI004- ground welds)
 170 - QC5- Inspect part completeness to step on W/O) Production .0000 * Attachments 180 HandFinish And realodine
 tube as per QSI 005 HandFinish2 (Pressure Wash p
 180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)And realodine tube as per QSI 005
 190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 12:35 TEMP: 320 FINISH: 1:05
 200 - (QC3- Inspect Part Finish)
 210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes
 before installing wearplates A/R Sikaflex-291 5163437 2-Coat D2594-3 O' rings with Petroleum Jelly and install on EF 19/09
 D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 5185197
 220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step
 Inspect for Foreign objects per QSI 024
 230 - 1 (Identify as per dwg & Stock Location: _____)Identify and pack for shipping as per PPPD205-634-141 Location :
 FG084
 235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004
 240 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	<u>5119507</u>
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	<u>5177095</u>
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	<u>5154382</u>
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5149158-1</u>
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>8x5103295-3/5x5103295</u>
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>8x5149607/6 (8)</u>
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5189025</u>
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5173297</u>
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5126188</u>
D4406-041	Fwd Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5190047</u>
D4406-043	Aft Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5185620</u>
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5158589</u>
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	<u>5178378</u>

M.U. 010586

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	4	0
150-Skidtubes - 3 - B4B	D2576-3	1	47	0
	D4202-1	24	857	0
210-Handfinish - 3-1- WingWalk-B4B	AN3-5A	2	194	0
	AN4-45A	8	53	0
	D2570	16	85	0
	D2594-1	8	106	0
	D2594-3	8	411	0
	D2855	1	52	0
	D4406-041	1	1	0
	D4406-043	1	0	0
	MS21042-4	8	116	0
	NAS1149D0332J	2	3,596	0

Part Specifications

Specifications could not be found.

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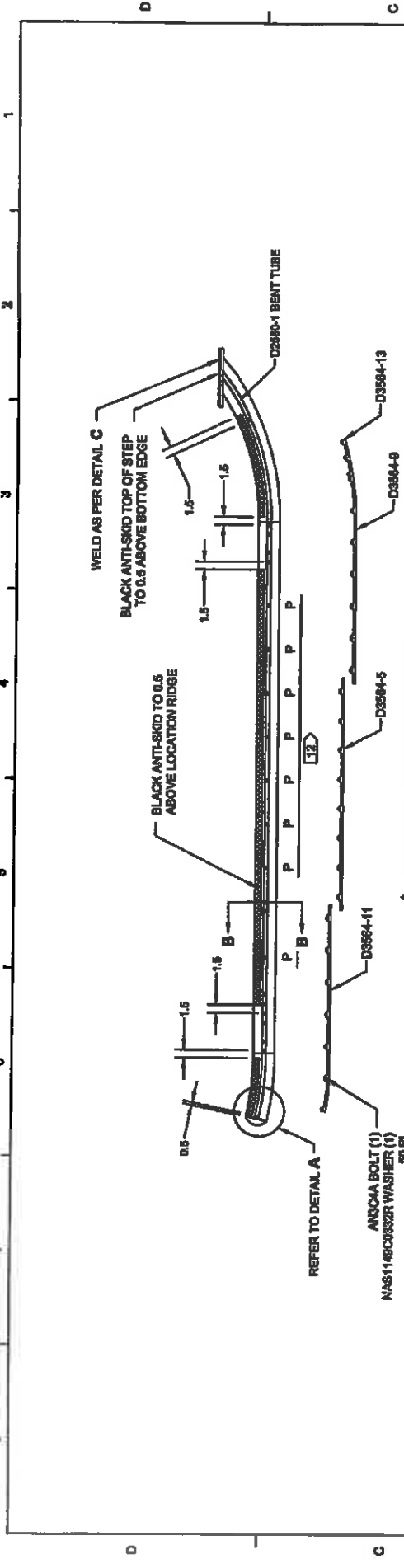
ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2680-041	SKIDTUBE ASSEMBLY
2		X			D2680-045	SKIDTUBE ASSEMBLY
3			X		D2680-047	SKIDTUBE ASSEMBLY
4				X	D2680-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2680-1-180	EXTRUSION
21			18	18	D2670	BUSHING
22	1	1	1	1	D2673-3	STEP
23		4			D2679	SPACER
24	16	16	8	8	D2684-1	PLUG
25	16	16	8	8	D2684-3	O-RING
26	1	1	1	1	D2686	208 WEB
27	1	1	1	1	D2685	AFT CAP
28	1	1			D2684-5	WEARSHOE
29	1	1			D2684-9	WEARSHOE
30	1	1			D2684-11	WEARSHOE
31	1	1			D2684-13	WEARSHOE
32	20	20	24	24	D4002-1	SPACER
33			1		D4006-041	WEARPLATE ASSEMBLY
34			1		D4006-043	WEARPLATE ASSEMBLY
35				1	D2681-1	FTD WEARPLATE
36				1	D2681-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AE5E-1032-130	INSERT
51	50	50			AK50A	BOLT
52	2	2	2	2	AK50A	BOLT
53			8	8	AK4-45A	BOLT
54	50	50			NAS114003032R	WASHER (AN880C10L)
55	2	2	2	2	NAS114003032J	WASHER (AN880J10L)
56			8	8	NS21042-4	NUT (CR NS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 006 4.1 PRIOR TO INSERTING D2686 WEB POWDER COAT (-041-047-048) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 006 4.3 BLACK ANTI-RUST PAINT AS INDICATED PER DART QSI 006 4.4.
- 3) TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2680-041 = 33.7 lbs
D2680-045 = 45.1 lbs
D2680-047 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2686 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 016 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR247 & DTR267 ONLY FOR D2680-041-045 TO LOCATE AND DRILL Ø0.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (Ø0.287) AFTER FINISH. INSTALL AK50A BOLTS AND NAS114003032R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2684-1 PLUG CW D2684-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2680-041-045 AND 8 PLACES FOR D2680-047-048)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2686 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

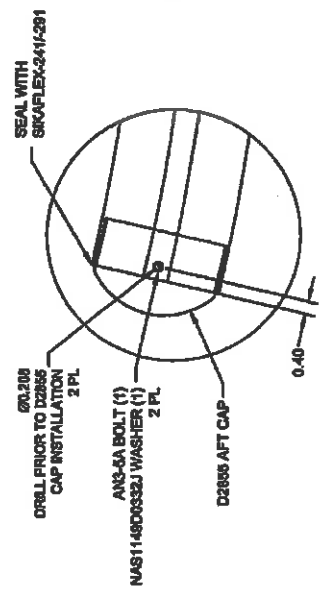
H	SHEET: PL DELETE D2680-1-6-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.08
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 8898	ALS	14.04.09
F	INCORPORATE DED D2680-E-1 PER PART2-218	DC	13.06.20
E	ADD D2680-047 (ZN C4-7) AND D2680-7 (ZN B3-4); INCLUDED DED D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR267 WAS D2687-308 (ZN C4-1)	RF	11.08.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DED P224 9153	PH	07.04.05
C	REDRAWN, INCLUDED DED 9084 9087	CP	06.08.26
B	AS MANUFACTURED	DS	04.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
INFO. APPR.	D2680	DRAWING NO.	REV. H
APPROVED	<i>[Signature]</i>	TITLE	SHEET 1 OF 8
DATE	17.06.09	SCALE	NTS
		205 SKIDTUBE ASSEMBLY	
		COMPANY: DART AEROSPACE LTD	
		1000 BURNHAMTHORPE RD, MISSISSAUGA, ONTARIO, CANADA	

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2017 JUL 05
5047-504

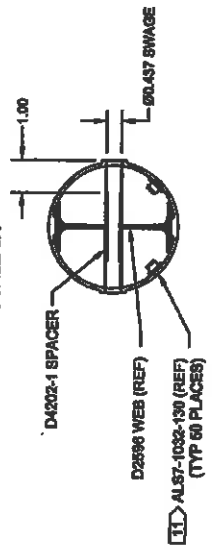


D2580-041 ASSEMBLY DETAIL

DETAIL A
SCALE 5X

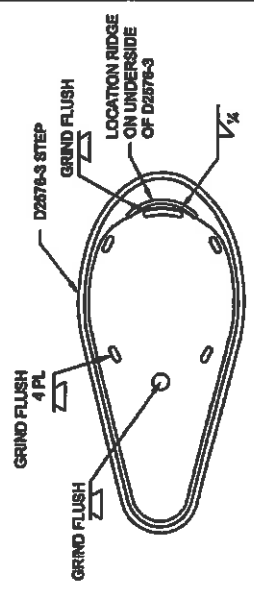


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.608 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X

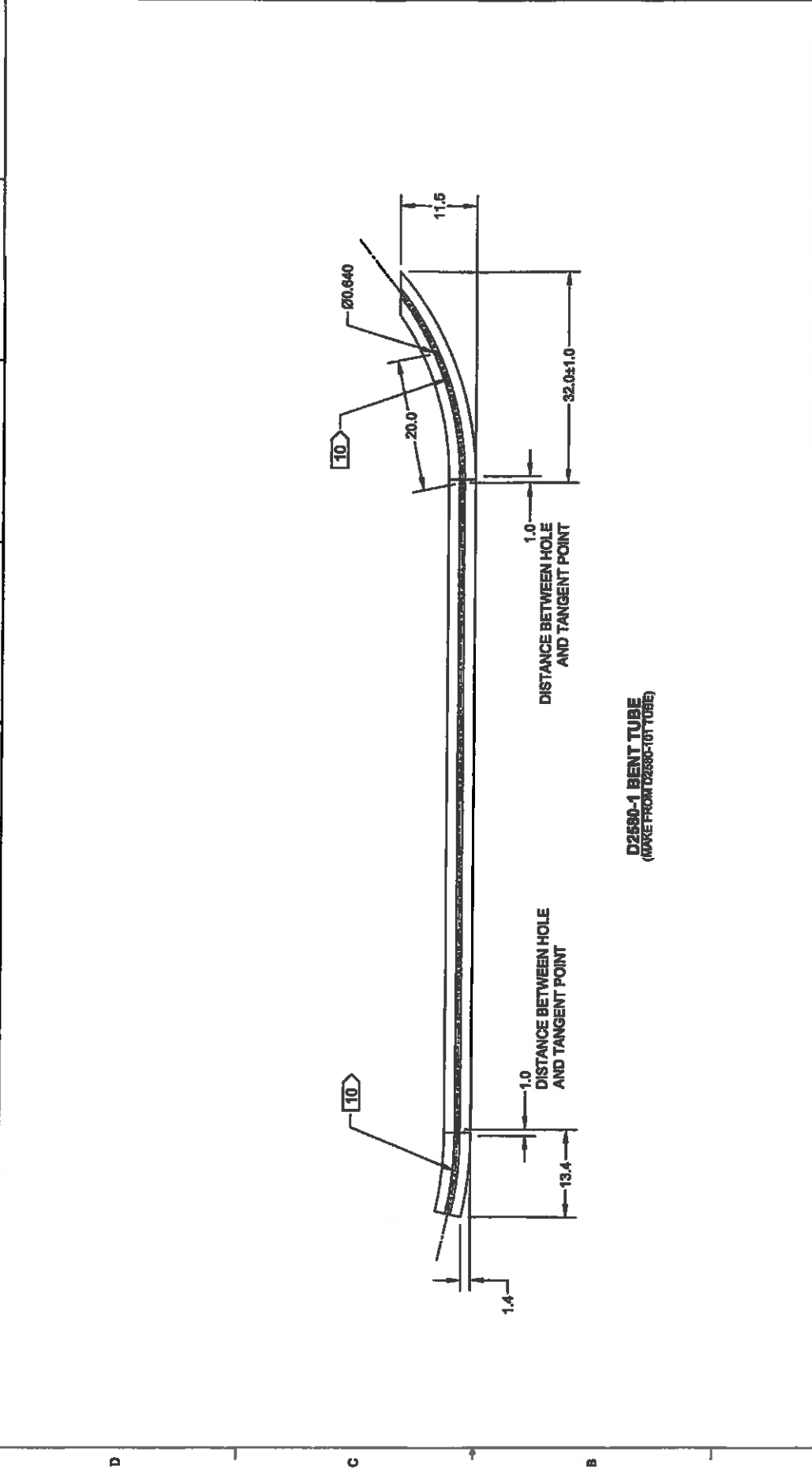


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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HARRISBURG, ONTARIO, CANADA
CHECKED	REV. H	SHEET 2 OF 8
INFO. APPR.	DRAWING NO.	D2580
APPROVED	TITLE	205 SKIDTUBE ASSEMBLY
DATE	SCALE	NTS
17.06.09		

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1 2 3 4 5 6 7 8 9



D2580-1 BENT TUBE
(WAVE FROM D2580-101 TUBE)

RELEASED
2017 JUL 05 4

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
INFL. APPR.		D2580
APPROVED		TITLE
DE APPR.		205 SKIDTUBE ASSEMBLY
DATE	17.08.00	SCALE
		NTE

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**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø.508 HOLES ONLY:**

1. CHAMFER HOLE 0.080 X 45°
2. INSERT D2679 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CEORE

Diagram of the rear of the cap showing the seal and fasteners. The diagram includes the following labels and dimensions:

- SEAL WITH SHAFLEX341-201**: Points to the seal on the rear of the cap.
- 13**: A dimension line indicating the distance from the center of the cap to the center of the seal.
- 0.0208**: A dimension line indicating the thickness of the cap.
- DRILL PRIOR TO D2865 CAP INSTALLATION**: A note indicating that drilling should be done before installing the cap.
- 2 PL**: A dimension line indicating the thickness of the cap.
- ANS-5A BOLT (1)**: A label for the bolt used to secure the cap.
- ANAS1148D6332J WASHER (1)**: A label for the washer used to secure the cap.
- 2 PL**: A dimension line indicating the thickness of the cap.
- D2865 AFT CAP**: A label for the cap.
- 0.40**: A dimension line indicating the distance from the center of the cap to the center of the bolt.

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.8018 HOLES ONLY:**

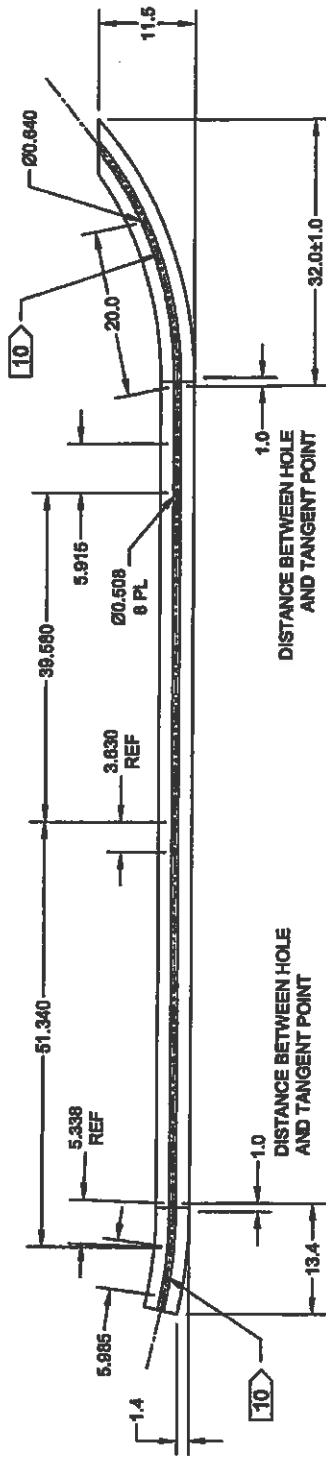
1. INSERT D402-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

2017 JUL 05 4
RELEASED

DESIGN DRAWN	DS SAD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
APPROVED		D2580	SHEET 4 OF 9
DES. APPR.		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

1 2 3 4 5 6 7 8

D C B A

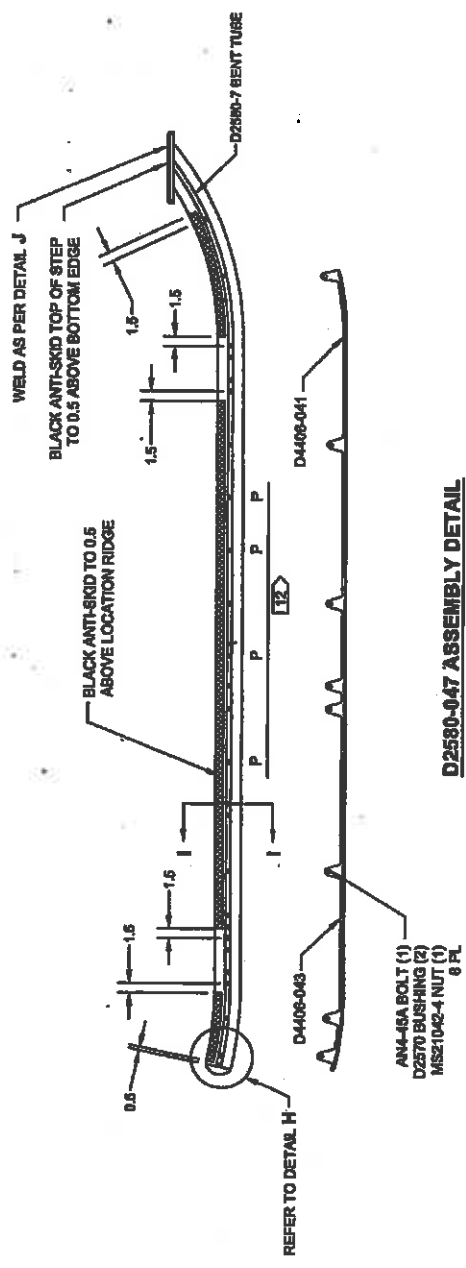


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05

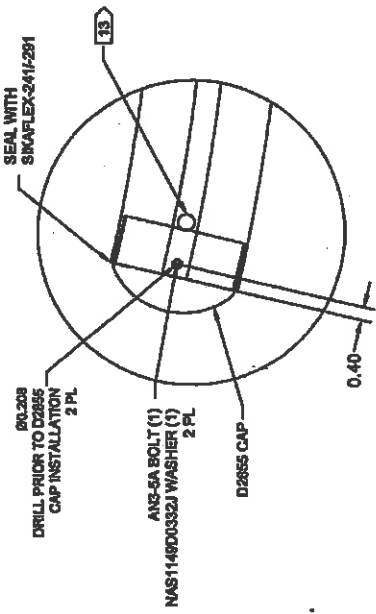
DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	REV. H	REV. H
DATE	DRAWING NO.	SHEET 8 OF 9
17.06.09	D2580	SCALE
	TITLE	205 SKIDTUBE ASSEMBLY
	DATE	NTS

1 2 3 4 5 6 7 8

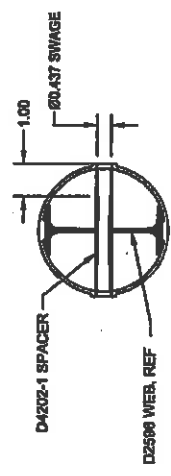


D2580-047 ASSEMBLY DETAIL

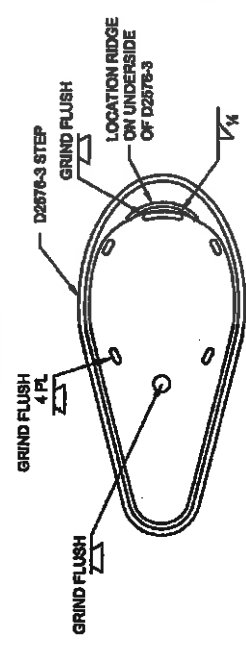
DETAIL H
SCALE 5X



SECTION I-I
SCALE 5X



DETAIL J
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

RELEASED
2017 JUL 05 4

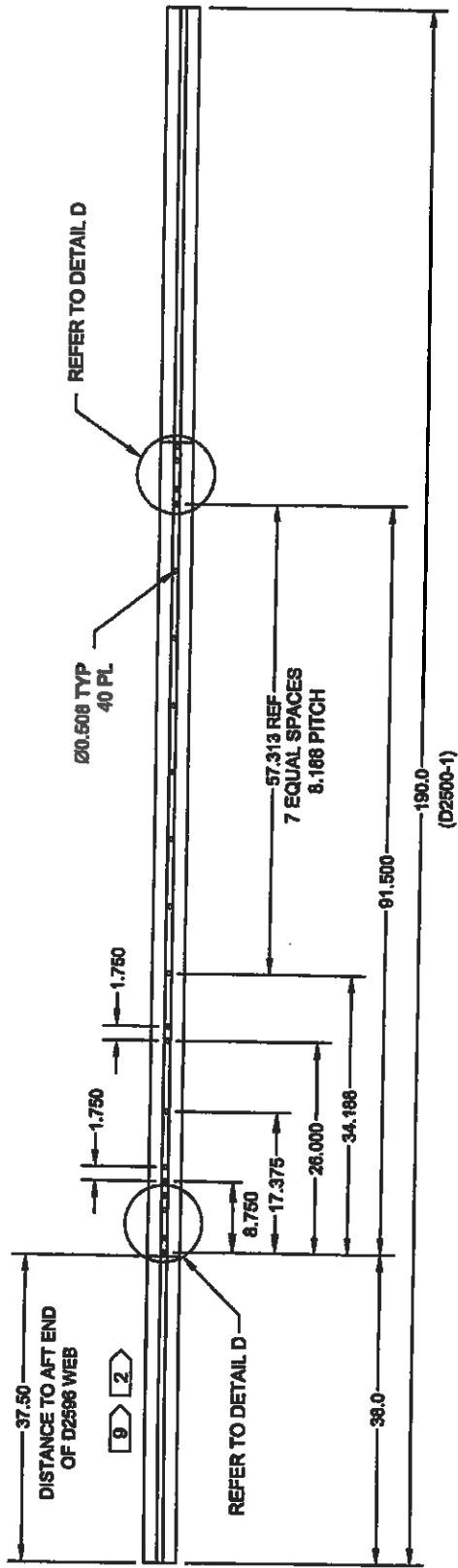
DESIGN	D8	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED		
ING. APPL	D2580	DRAWING NO.
APPROVED		
DE APPR		
DATE	17.06.09	
		REV. H
		SHEET 8 OF 8
		SCALE
		NTS
		TITLE
		205 SKIDTUBE ASSEMBLY
		COMP. PREPARED BY DART AEROSPACE LTD
		FOR THE USE OF THE CUSTOMER ON THE BASIS OF THE INFORMATION PROVIDED



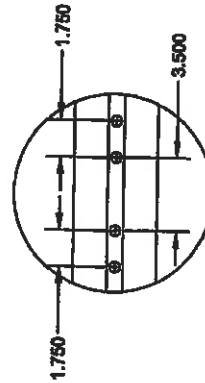


2017 JUL 05 4

DESIGN	DS	DART AEROSPACE LTD HANBESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 5 OF 9 SCALE NTS 205 SKIDTUBE ASSEMBLY
DRAWN	SAD	
CHECKED	<i>Mike</i>	
INFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	CONSTRUCTION OF DART AEROSPACE LTD THIS DOCUMENT IS MEANT TO BE A WORKING DRAWING. IT IS SUBJECT TO THE PERMANENT MODIFICATION BY THE COMPANY. IT IS NOT TO BE USED FOR CONSTRUCTION WITHOUT THE PERMISSION OF THE COMPANY.



D2590-101 TUBE



DETAIL D
SCALE 5X

RELEASED
2017 JUL 05

DESIGN	D6	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO.
MFG. APPR		D2580
APPROVED		TITLE
DE APPR		205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTB
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		FOR THE DART AEROSPACE LTD